

Work Order ID 166003

Thursday, September 07, 2017 11:20:41 AM

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Item ID: D3172-041 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Basket Base Assembly
Start Date: 9/13/2017 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 9/25/2017 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:**  **Date:** SEP 07 2017 **Tooling:** **Date:** **Run Start** ***NR1***
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3172	D								

100

0.00

100

Large Fab

Large Fab

Memo

20.00

Large Fab

1-Cut Qty 4 D3166-1 as per Dwg D3172

2-Cut 3/4" x 3/4" square tubing as per Dwg D3172

3-Drill holes in D3172-3 as per Dwg D3172

4-Deburr & Remove all markings from material

5-Weld all ribs as per Dwg D3172 using Welding Table

6- Use DT 8996 jig to locate D3174-1 as per dwg

7- Weld D5365-1 as per dwg in (2) locations. From edge of back basket corn
(without hinge) to bottom of D5365-1 lug. And (2) located at the front.

8- Weld mesh as per dwg

DAS
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SEP 20 2017

1x

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.02				1		17-9-21	PC
120 *120* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.02				1		17-9-21	PC
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.45				1		17-09-22	PC

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 138014.</i> Memo 1ST COAT: <i>8:45</i> START TIME: <i>375°</i> OVEN TEMPERATURE: <i>9:00</i> FINISH TIME: <i>9:00</i> ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.72							<i>1 of 17-09-22</i> <i>34 0.89</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.20							<i>1 of 12/09/25</i> <i>15 0.89</i>

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>WLF</u>	0.00							
150									
Packaging	Memo	0.02							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

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9-89 **SEP 27 2017**

 **SEP 27 2017**

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D3172-041

Required Date: 9/25/2017

Required Qty: 1.00

Comments: IPP Rev:B04.01.05Added Step 5 inspectionKJ/RF
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D
11.04.04 added pressure wash DD VEF:EC IPP REV:E 16.11.03 AS
PER DWG REV.D DD VEF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3 *D2232-3* Basket Hinge		Manufactured	No			100	Each	12.0000	2	2			
						B157388 → 1			**			2017-09-11	
						B156858 → 1							
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		12							
				156858		11							
				157388		1							
D2327-3 *D2327-3* Spacer Bushing		Manufactured	No			100	Each	21.0000	2	2			
						B154190 → 2			**			2017-09-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		21							
				154190		21							
D2581 *D2581* Mounting Bracket		Manufactured	No			100	Each	46.0000	2	2			
									**			2017-09-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		46		B161800 → 2					
				161800		10							
				162923		8							
				164446		28							

Picklist Print

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Parent Item: D3172-041

D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 9/13/2017

Required Date: 9/25/2017

Start Qty: 1.00

Required Qty: 1.00

D3166-1

Manufactured No

100

Each

16.0000

4

4

D3166-1

Basket Hoop

**

DC 2017-09-11

Location

Loc Qty

Loc Code

WA004

16

16

160536

100

Each

7.0000

8

8

D3174-1

Manufactured No

D3174-1

Mounting Lug

**

DC 2017-09-11

Location

Loc Qty

Loc Code

WA004

7

7

158014

100

Each

8.0000

4

4

D5365-1

Manufactured No

D5365-1

Lug

**

DC 2017-09-11

Location

Loc Qty

Loc Code

WA004

8

8

158501

100

sf

610.9221

48

48

M304EX0.75-16F

Purchased No

M304EX0 75-16F

Expanded Metal Flat SS

**

M138390 → 48

DAS

43

9-89

SEP 20 2017

Location

Loc Qty

Loc Code

WA004

610.9221052

M137765

9.29473684

M138128

121.627368

M138390

480

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Shop Packet Print

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Picklist Print

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Parent Item Name: Basket Base Assembly

Start Date: 9/13/2017

Required Date: 9/25/2017

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

312.1600

51

53.68421

M304TS0 750W 065

**

DC 2017-09-11

304 SQ Tube .75x.75x.065W

Location

WA004

m137065

m137273

m137401

m138008

Loc Qty

312.16

0.4

36.76

79

196

Loc Code

B137401 → 20

B137273 → 10

~~B137401~~ → 24

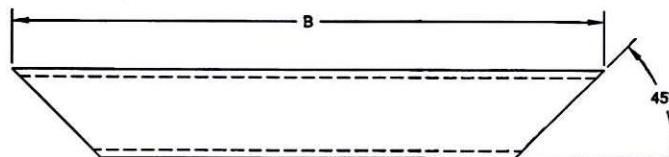
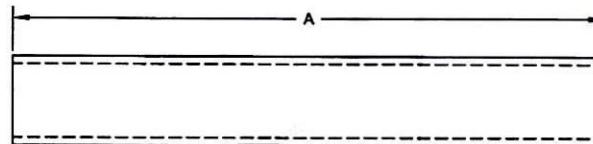
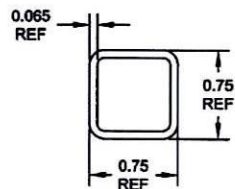
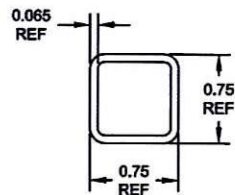
B138008 → 24

PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG
D5365-1	4	N/A	N/A	LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166003 JK

SEP 07 2017



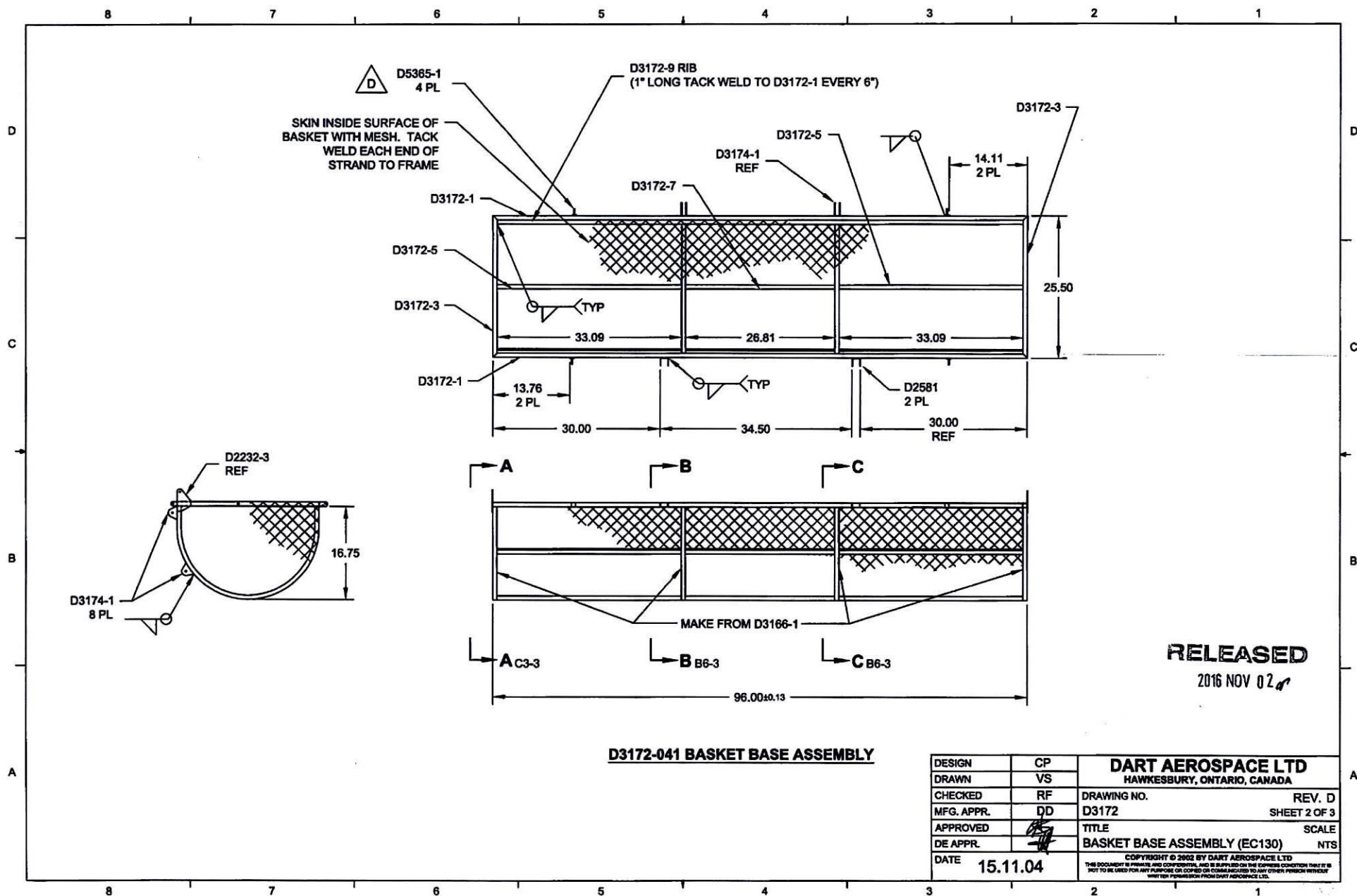
RELEASED

2016 NOV 02
ECN 16-515 qf

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

D	REPLACED D2012-117 WITH D5365-1 (ZN C6-1, D5-1, C5-2, D3-2, C3-2)	VS	15.11.04
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	DD	D3172	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET BASE ASSEMBLY (EC130)	NTS
DATE	15.11.04	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN	CP	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	DD	D3172	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
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